

**Work Order ID 87022**

Monday, July 09, 2012 8:59:25 PM

**\*87022\***

Page 1

Item ID: D4522-13 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Handle Shaft Adapter  
Start Date: 7/10/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 7/18/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference: *12.07.09*  
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4522	B
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100

0.00

**\*100\***

Doosan

Doosan Lathe

Memo

TURN AS PER DWG AND FOLIO FB123

FOLIO REV: N/ADWG REV: 3

DEBURR

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*2* *0*

*2* *0*

*12/7/17**68-  
E1  
13  
070*



**Work Order ID 87022**

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**\*87022\***

Page 2

Item ID: D4522-13

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Handle Shaft Adapter

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/18/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Jul 12-07-12

2

130

Identify as per dwg & Stock Location: SI 17 0.00**\*130\***

Packaging

Memo

0.00

Packaging

2

SD  
12-7-19

140

QC21- Final Inspection - Work Order Release 0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/7/20

ME  
12-07-19

1

2

3

4

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# Picklist Print

Monday, July 09, 2012 8:59:25 PM

Page 1

Work Order ID: 87022

Parent Item: D4522-13

Parent Item Name: Handle Shaft Adapter

Start Date: 7/10/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No				f	5.9822		0.3578947			
303 Round Bar 1.00													

Location

Loc Qty

Loc Code

MAT028

5.982157895

120866

0.7

121070

3.31515789

121282

0.45

121728

1.517

122386

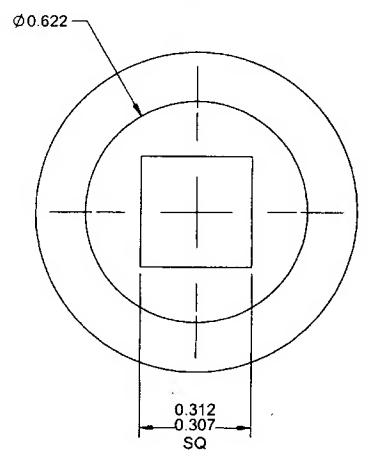
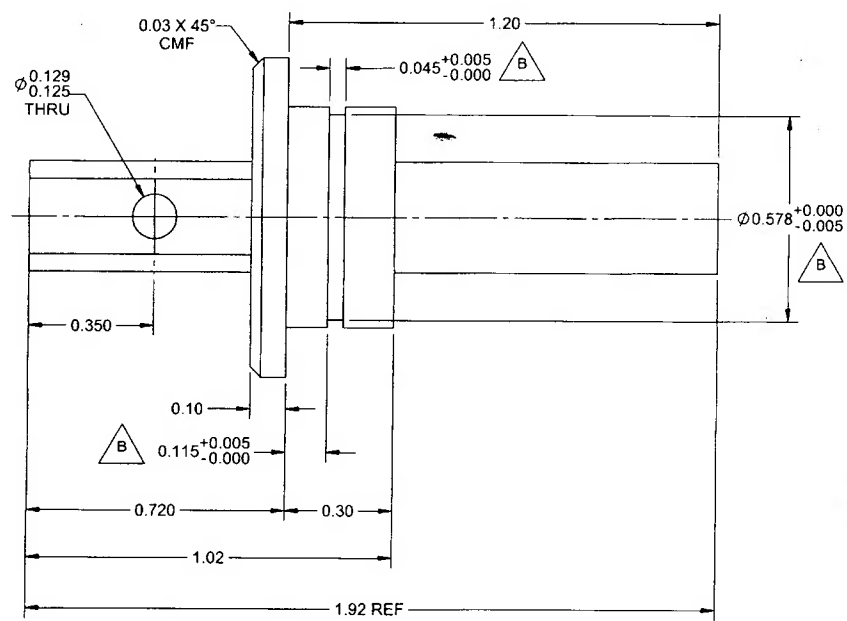
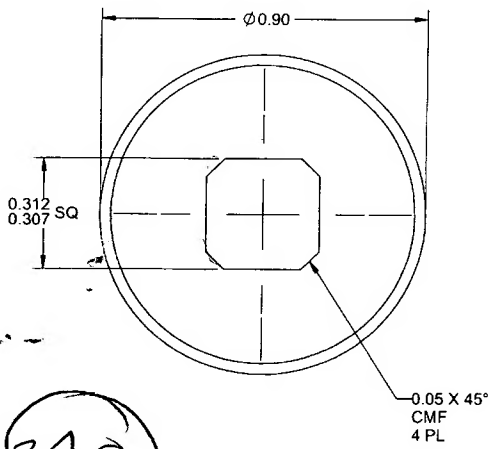
.4 Lt

12/2/12  
31  
DAS

441

097344

86619



370

0025  
005 0707

RELEASE  
2012-06-13

**D4522-13 HANDLE SHAFT ADAPTER**

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582  
REF DART SPEC M303R1.00 OR  
AISI 304/316 SS ROUND BAR PER ASTM A276  
REF DART SPEC M304R1.00
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6
- 7) WEIGHT: 0.08 lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	Y	DRAWING NO. <b>D4522</b>	REV. B
MFG. APPR.		TITLE <b>DOOR LATCH ASSY (412)</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	12.04.17		

SHEET 16 OF 23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 86619
<b>Description:</b> Handle shaft Adapter	<b>Part Number:</b> N4522-13
<b>Inspection Dwg:</b> N4522 Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.90	±.030	Ø.899	/		SI-9	UOL
.307-.312	N/A	.312	/		SI-5	OK
.05X45°	±.030	.05X45°	/			
Ø.125-.129	N/A	.128	/			
-.350	±.010	-.347	/			
.03X45°	±.030	.03X45°	/			
1.20	±.030	1.20	/			
.045	+0.005/-0.000	.0455	/			
Ø.578	+0.001/-0.005	Ø.578	/			
1.92	±.030	1.922	/			
1.02	±.030	1.027	/			
-.30	±.030	-.301	/			
-.720	±.010	-.723	/			
.115	+0.005/-0.000	.116	/			
.10	±.030	.100	/			
Ø.622	±.010	Ø.622	/			
.307-.312	N/A	.312	/			

<b>Measured by:</b> DAS 13	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 12/7/17	<b>Date:</b> 12.07.18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15